Wednesday, 9/12/2007 12:13:59 PM Date Kim Johnston User **Process Sheet** : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 34617 **Estimate Number** : 10940 : D29381 : NIA **Part Number** P.O. Number S.O. No. : MA D2938 REV C **Drawing Number** : 9/12/2007 This Issue : N/A Project Number Prsht Rev. : MACHINED PARTS : C Drawing Revision First Issue :NIA 33355 Material **Previous Run** Each : 10/5/2007 Qty: 10 Um: **Due Date** Written By Checked & Approved By New DWG rev (mpp 2069) Est: 00.06.26 Comment Est Rev:C As per Rev C 07-03-19 JLM **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 7075-T7351 2X6.25X7.875 D6101003 1.0 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length Batch No: (D6101-003) 16 HAAS CNC VERTICAL MACHINING #1 2.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet W. 5-Deburn 10) CONVENTIONAL MILLING MACHINE MILLING CONV 3.0 Comment: CONVENTIONAL MILLING MACHINE BG 07.10.07 Machine Keyway and inspect per attached dimension sheet (w) INSPECT ALL DIM TO DIM SHEET QC1 4.0 Comment: INSPECT ALL DIM TO DIM SHEET (i) 07.10.07

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W/O:			W	ORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
: : : : :									
Part No	:	PAR #:	Fault Cate	egory: No					
NCR:			WORK ORE	DER NON-CONFORMANC			u:	Date:	
		Description of NC		Corrective Action Section B		1,,			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section Section	on C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Wednesday, 9/12/2007 12:13:59 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE Customer: CU-DAR001 Dart Helicopters Services Part Number: D29381 Job Number: 34617 Job Number: Description: Seq. #: Machine Or Operation: SECOND CHECK 5.0 QC8 0/08 Comment: SECOND CHECK HAND FINISHING RESOURCE # HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 POWDER COATING POWDER COATING 7.0 M105068 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 Comment: INSPECT POWDER COAT 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 Comment: FINAL INSPECTION/W/O RELEASE 1 8/10:10 Job Completion

Dart Aerospace

W/O:	Tospace		WC	ORK ORDER CHANGE	S				
DATE	STEP	PR	PROCEDURE CHANGE By					Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No) :	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	:	Date:	
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NCR:			WORK ORDE	ER NON-CONFORMAN	ICE (NCR)			
DATE	OTED	Description of NC		Corrective Action Section		Verifica	Verification		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34617
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		124	.124	.124	.124		
В	0.100	0.140		.123	1173	.123	173		
С	0.100	0.140		- 11-1	.114	.11-(. 114		
D	0.210	0.230		.276	. 776	1226	. 276		
E	1.245	1.255		1.750	1.250	1.250	2.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		7.500	2.500	7.500	2.500		
Н	0.510	0.515		,510	.510	1510	-510		
i	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	7.500	7.500		
K	0.257	0.262		. 258	- 258	. 258	.758		
L	0.312	0.317		.313	.313	.313	. 313		
М	0.235	0.240		. 538	. 238	.238	. 238		
N	0.100	0.140		.127	177	.127	.127		
0	0.540	0.560		- 546	.546	1546	. 546		
Р	0.490	0.510		.507	.502	1507	.502		
Q	3.715	3.725		3.720	3.770	3.770	3.770		
R	2.720	2.760		7-750	2.750	7.750	7.750		
S	0.240	0.270	· · · ·	.757	. 252	.252	.752		
Т	0.100	0.180		140	140	.140	.१५७		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.319	.319	.319	.319		
X	1.250	1.270		1.265	1.765	1.265	1.765		
Y	1.565	1.585		1.576	1.576	1.576	1.576		
Z	0.178	0.198		1188	. 188	.188	. 188		
AA									
AB									
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AH									
	Acc	ept/Reje	ct				l		

Measured by:	36	Audited by T. F.
Date:	07.10.07	Date: 07/40/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
				<i>J~''</i>

DART AEROSPACE LTD	Work Order:	34617
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	15	2-6	187	A 8	Ву	Date
Α	0.100	0.140		. 12-4	112-(177	.174		
В	0.100	0.140		.123	.123	1773	.123		
С	0.100	0.140		: 114	: 114	111-4	.114_		
D	0.210	0.230		.226	.276	.776	.226		
E	1.245	1.255		1.250	1.250	1.750	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.750		
G	2.495	2.505		7.500	7-500	2.500	7.500		
Н	0.510	0.515		.510	.510	.510	1510		
1	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		7.500	7.500	2.500	7.500		4
K	0.257	0.262		. 258	. 258	.258	.758		
L	0.312	0.317		.313	.313	,313	1313		
M	0.235	0.240		1239	. 739	. 234	.239		
N	0.100	0.140		.127	.127	.127	.127		
0	0.540	0.560		.548	.548	,548	.548		
P	0.490	0.510		.506	.506.	.506	.506	·	
Q	3.715	3.725		3.770	3.770	7.720	3.770		
R	2.720	2.760	J	2.740	7.740	7-740	7-740		
S	0.240	0.270		.252	. 757	.757	. 257		
Ť	0.100	0.180		.140	11-10	1140	- 140		
Ū	1.625	1.635		1.630	1.630	1-630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.319	.319	.319	.319		
X	1.250	1.270		1.765	1.765	1.265	1.265		•
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	, १८८	. 188	.188		
AA			A 11						
AB						. <u>.</u>			
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AD	-		· · · · · · · · · · · · · · · · · · ·						
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AH									
	Acc	ept/Reje	ct	<u> </u>				1	

Measured by:	86	Audited by J. F.
Date:	07-10.07	Date: 07/10/08

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	34617
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

	inspect diffiensions riigniignted on inspe				Recorded Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	19	210	3	4	Ву	Date
A	0.100	0.140		125	.125				.,.
В	0.100	0.140		.179	.129				
С	0.100	0.140		.115	.115				
D	0.210	0.230		.225	.775				
Е	1.245	1.255		1.750	1.250	4			
F	1.245	1.255		1.750	1.250				
G	2.495	2.505		2.500	2-500				
Н	0.510	0.515		.510	.510				
	1.572	1.582	- 100	1.577	1.577				
J	2.495	2.505		7.500	2.500				
K	0.257	0.262	,	.158	. 258				
L	0.312	0.317		.313	. 313				
М	0.235	0.240		. 738	- 238				
N	0.100	0.140		.126	126				
0	0.540	0.560		.550	·55c				
Р	0.490	0.510		1505	· 50 S				
Q	3.715	3.725	****	3.720	3-120				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270	1.7	. 752	. 252				
T	0.100	0.180		.140	1140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1-367	1.367				
W	0.316	0.321		.719	.319				
X	1.250	1.270		1.765	1.265				
Υ	1.565	1.585		1.575	1.575	-			
Z	0.178	0.198		.188	.188				
AA									
AB				-					
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	56	Audited by T-C.
Date:	07.10.07	Date: 02//0/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С	07.03.21	Revised per drawing revision C	KJ/JLM 🔏	
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